

Work Order ID 77217

77217

Tuesday, November 29, 2011 12:57:06 PM

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Eagle

Item ID: D412-785-003-401 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pax Speaker Mount, Aft
 Start Date: 11/29/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 11/30/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: *MF* Date: 11-11-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-785-003-101	B								

100 FLOW WATER JET 0.00

100 FLOW CNC Waterjet 0.00 B11-12-5
 Waterjet Memo
 1-Cut as per Dwg
 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary (3)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110 QC Memo 0.00 B11-12-5
 Quality Control

120 QC8- Inspect parts - second check 0.00

120 QC Memo 0.00 Su1266 (4)
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pax Speaker Mount, Aft

Start Date: 11/29/2011 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/30/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Small Fab

Small Fab

Memo

0.00

Small Fab

c'sink as per dwg

0.00

n/a

150

150

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

160

160

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

3X4 m-11/12/06

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

180	Identify as per dwg & Stock Location: <u>SKIP</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									

190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

3 BK 11-12-6

11/12/7 (3)

11/12/7

Eagle

M. Fauter
11/18/07

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 77217

Parent Item: D412-785-003-401

Start Date: 11/29/2011

Required Date: 11/30/2011

Parent Item Name: Pax Speaker Mount, Aft

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-09-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No				sf	76.8184		1.0526316			
										1811-12-5			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT022			76.818421						
				117684			76.818421			117684		(3)	

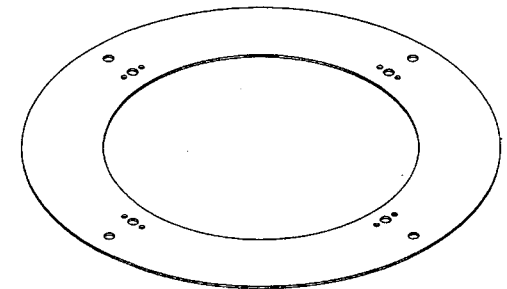
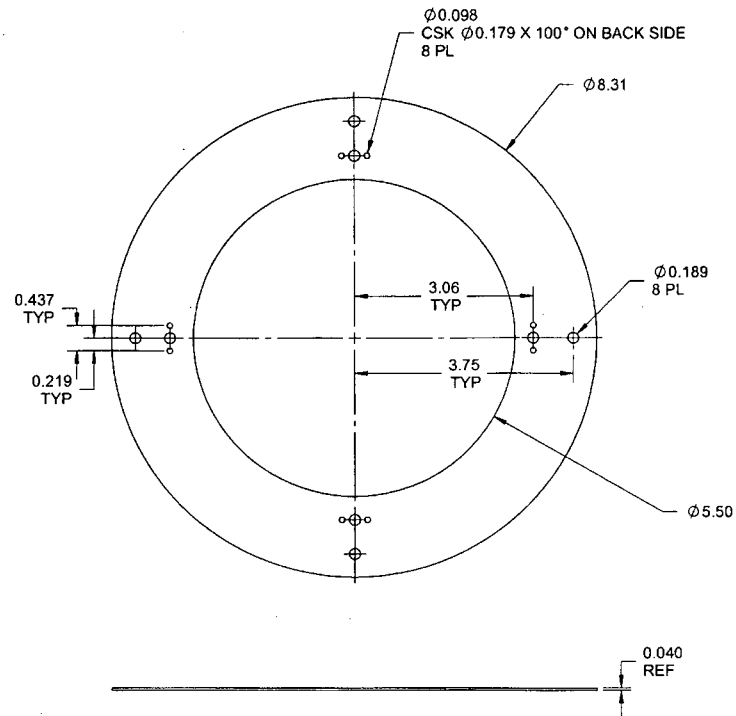
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D412-785-003-401 PAX SPEAKER MOUNT AFT

77217

RELEASED
2010-08-25

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
 - 2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.12 lbs

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-003-101	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
DATE	09.10.09	<small>COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD.</small>	

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Dart Aerospace Ltd

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